

Date: Friday, 5/25/2007 8:36:33 AM
User: Kim Johnston

Process Sheet

POSITIVE RECALL

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32643
Estimate Number : 12578
P.O. Number : N/A
This Issue : 5/25/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : SMALL /MED FAB
Previous Run : 31443
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 07.05.24 EC

Drawing Name : ARM

EFFECTIVE 07.06.05 AUTH
RELEASED 07.06.06 DATE

Part Number : D3560041
Drawing Number : D3560 REV.B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 6/5/2007

Qty: 30 Um: Each

Additional Product

Job Number:

Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"

Comment: Qty.: 1.4648 f(s)/Unit Total : 43.9425 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: M17625

M104598 x 20

J.F.I SA 07.05.30

2.0 BAND SAW BAND SAW

Comment: BAND SAW

Cut blanks 16.750" long

J.F.I SA 07.05.30

3.0 HAAS1 HAAS.CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA693 Rev: AA & Dwg D3560 Rev: B

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

J.F.I SA 07.06.01

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK

Comment: SECOND CHECK

J.L 07/06/07 20

Date: Wednesday, 15/08/2007 7:41:39 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32643

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

See page #1

W/A EP 2700/20

7.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

PLATE B32641

PE 07-08-16

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

(P70) Ins. Page

PE 07-08-20

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/01

07-10-20 16:44

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-10-01 10

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Date: Wednesday, 15/08/2007 7:41:39 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32643

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

17.0

EMP COST ADJ

Employee Labour Cost Adjustment



Comment: Sub-Contracting Employee Labour Cost Adjustment

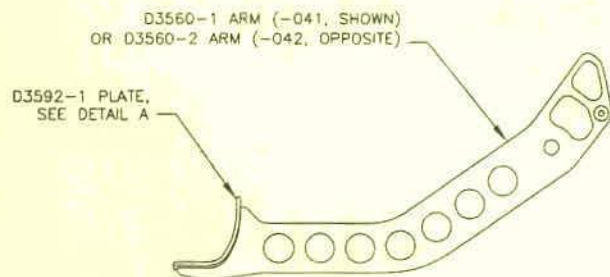
Job Completion



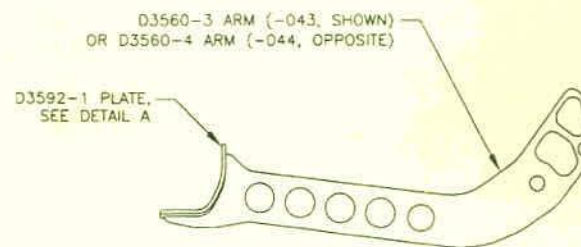
Used Ser Testlines

00184

4 07-10-02
12-10-01

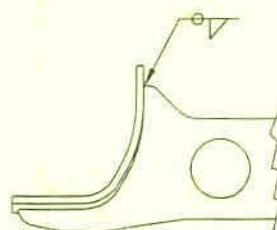
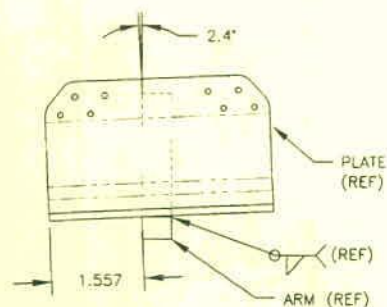


D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)

4/032643



DETAIL A
(SCALE 1:1)

GENERAL NOTES

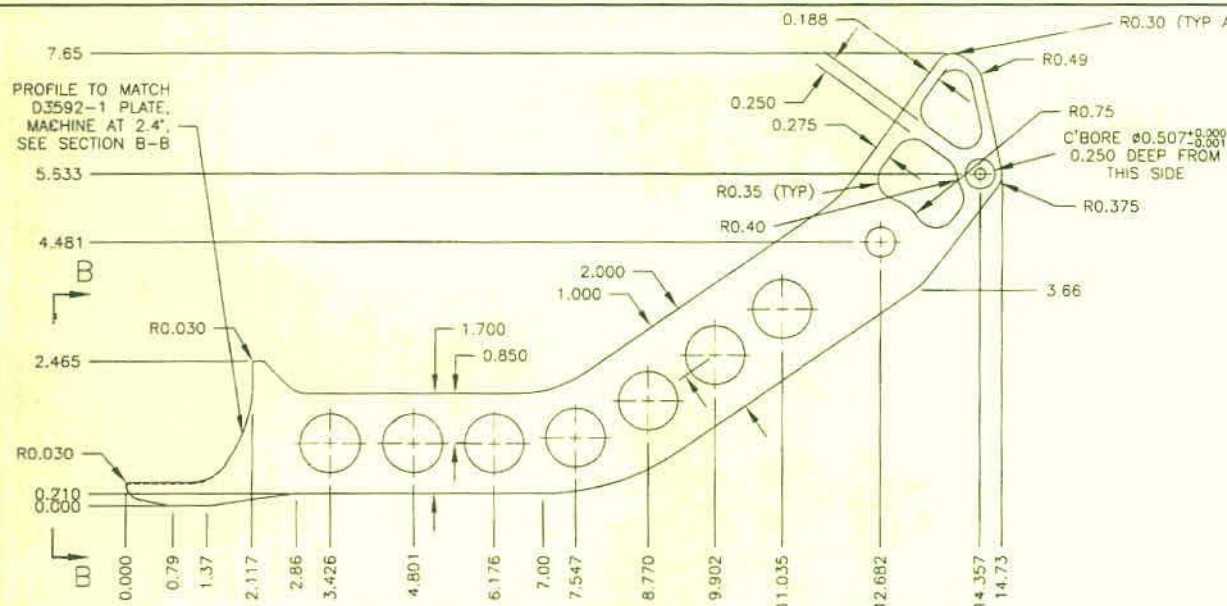
- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.06.19

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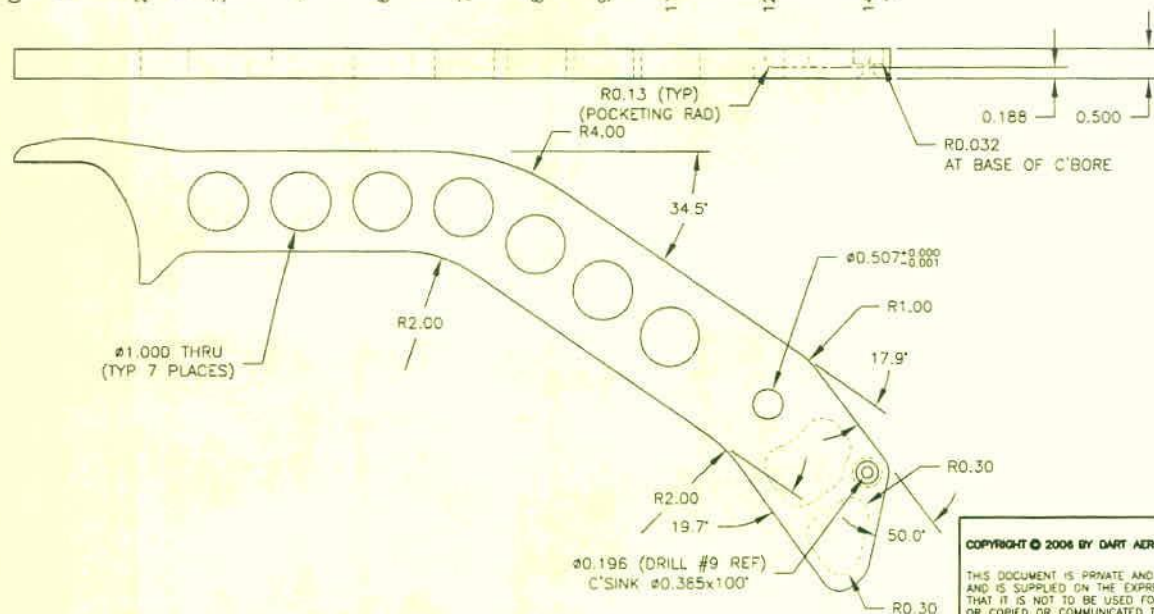
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C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	<i>qp</i>	DRAWN BY <i>qp</i>
CHECKED	<i>qp</i>	APPROVED <i>qp</i>
DATE	07.06.19	TITLE
		ARM WELDMENT
		DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
		DRAWING NO. D3560
		REV. C
		SHEET 1 OF 3
		SCALE 1:4

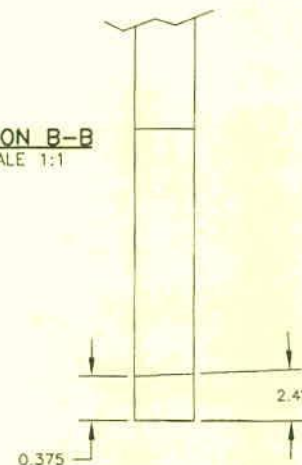


D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION B-B SCALE 1:1

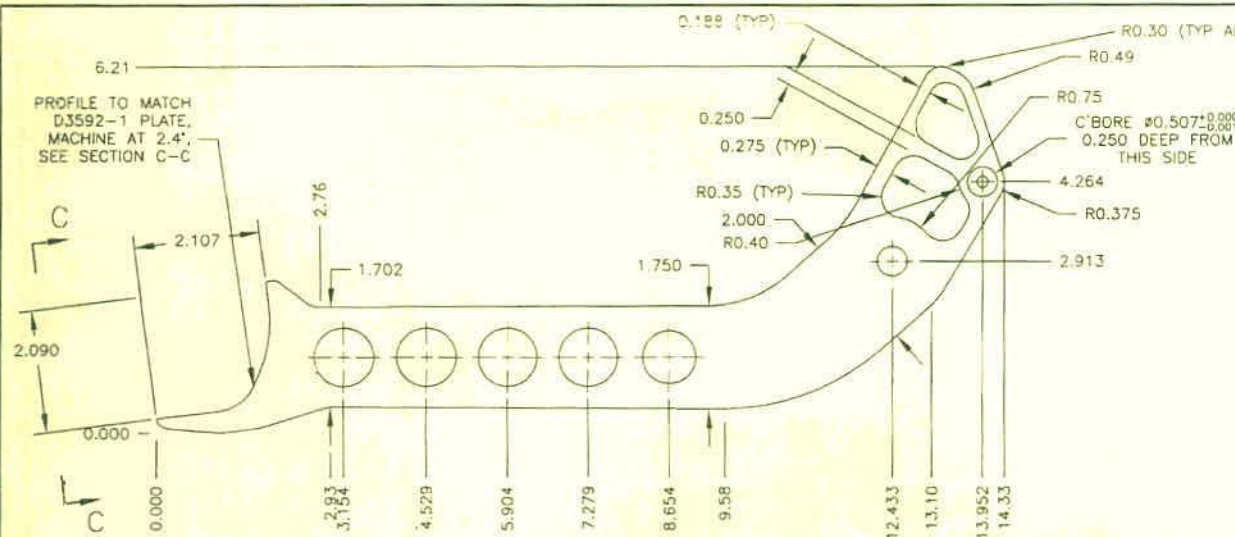


RELEASED
07.06.29

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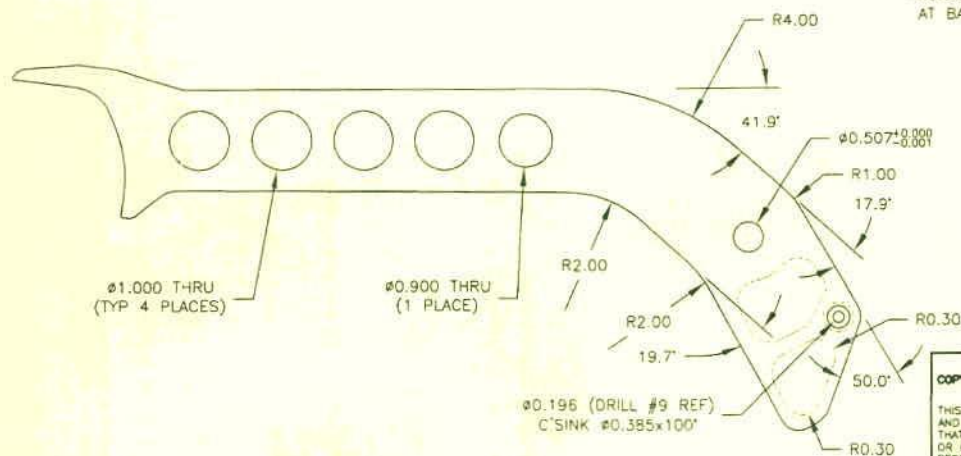
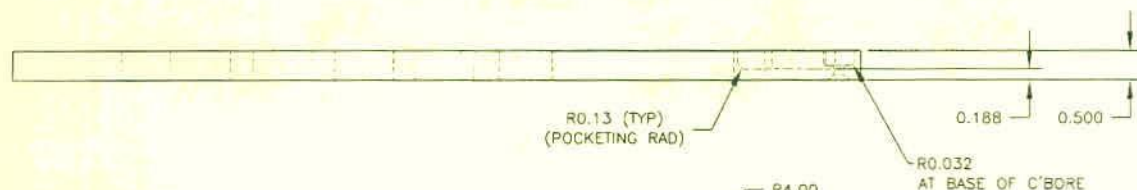
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DESIGN	9P	DRAWN BY	9P	DART	DART AEROSPACE LTD. WARRICKSURY, OHTARIO, CANADA
CHECKED	dt	APPROVED	dt	DRAWING NO.	D3560
DATE	07.06.19	TITLE	ARM WELDMENT	REV. C	SHEET 2 OF 3
				SCALE	1:2

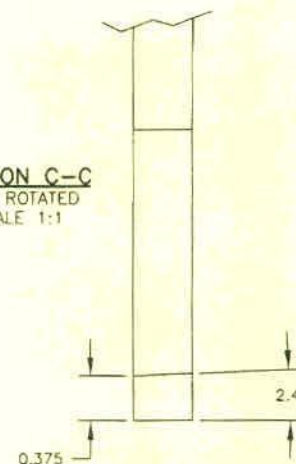


D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C VIEW ROTATED SCALE 1:1



RELEASED
07.06.19

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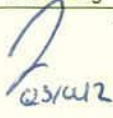


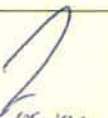

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DESIGN 9P	DRAWN BY 9P	DART	DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D3560	REV. C SHEET 3 OF 3
DATE 07.06.19	TITLE ARM WELDMENT	SCALE 1:2	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.08.22	0.0	Qty 6 parts have cracks on the 03592-1 plate, due to too much heat transfer to gain deeper penetration during welding. R.C.: Too hot of weld on the plate - Employee error.	 Q51012	<div>Remove the 03592-1 plate from the arm, grind any access weld flush off the arm.</div> <div>Verify arm by Q.C</div> <div>Pick new 03592-1 032661 weld plate per Dwg, with normal heat.</div> <div>Scrap: destroy.</div>	07.08.23  07.08.23	07.08.23  07.08.23	 Q51012	 07.08.22

NOTE: Date & initial all entries

